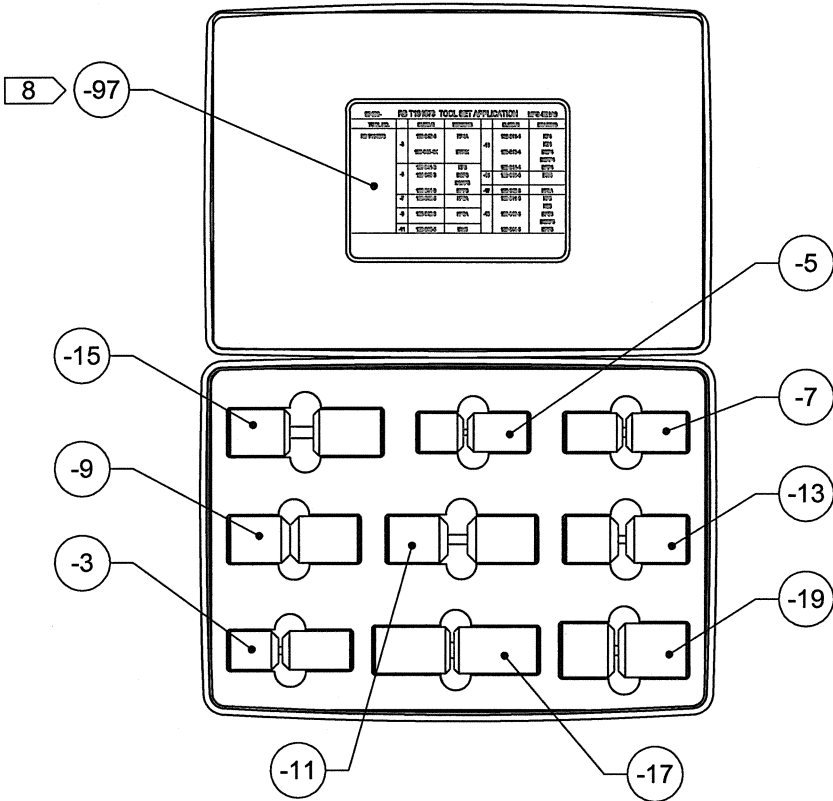


ITEM #	QTY	PART #	PART TITLE
-1	1	RB T101873-1	PACKAGING ASSEMBLY
-3	1	RB T101873-3	3 ASSY
-5	1	RB T101873-5	5 ASSY
-7	1	RB T101873-7	7 ASSY
-9	1	RB T101873-9	9 ASSY
-11	1	RB T101873-11	11 ASSY
-13	1	RB T101873-13	13 ASSY
-15	1	RB T101873-15	15 ASSY
-17	1	RB T101873-17	17 ASSY
-19	1	RB T101873-19	19 ASSY
-97	1	RB T101873-97	CONTENT PLACARD
98	1	RB41011	DART PLACARD
99	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

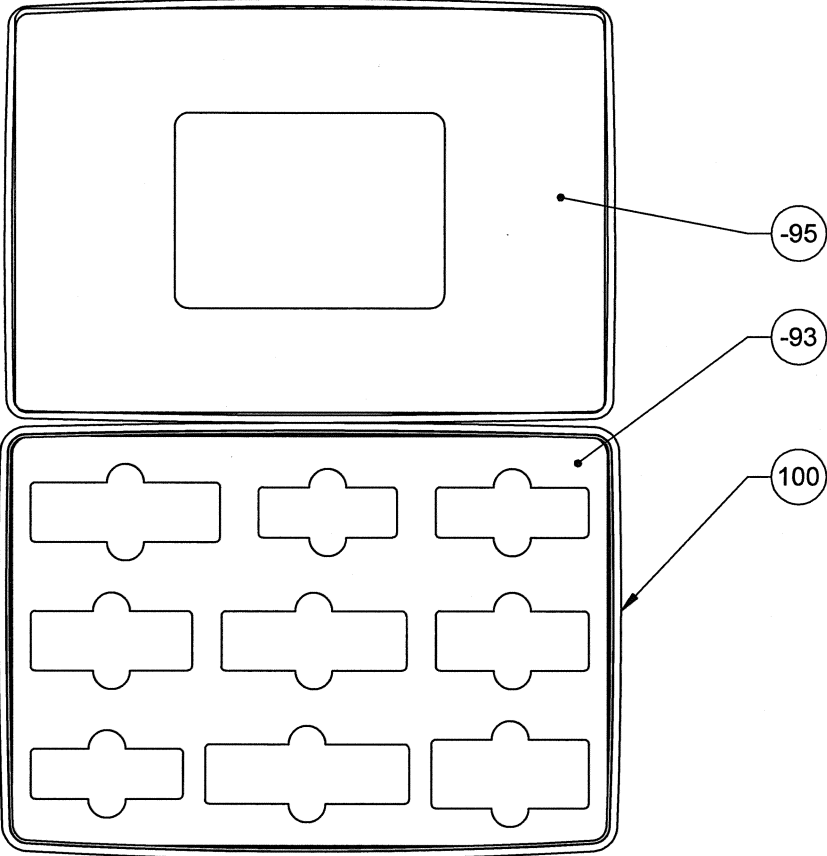


RB T101873 RING STAKING TOOL

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: ENGRAVE THE TOOL P/N ON THE DART PLACARD WHERE INDICATED
 - 7) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
 - 8) HOT GLUE THE CONTENT PLACARD ONTO THE TOP FOAM
 - 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

D	SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED -1 PRESS & BASE PARTS HEAT TREAT WAS 58-62 RC IS 48-52 RC & ADDED FINISH -93 UPDATED CUTOUT DIMENSIONS -95 ADDED CUTOUT FOR CONTENT PLACARD		19-691	MBB
	REV.	DESCRIPTION	ECN #	BY
DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	MBB			
CHECKED	KPT	TOOL PART #	REV. D	
MFG. APPR.	JFC	RB T101873	SHEET 1 OF 9	
APPROVED	VH	TITLE	SCALE	NTS
DATE 4/30/2019		RING STAKING TOOL	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-93	1	RB T101873-93	BOTTOM FOAM
-95	1	RB T101873-95	TOP FOAM
100	1	PELICAN #APP-1470-E	PELICAN CASE 1470

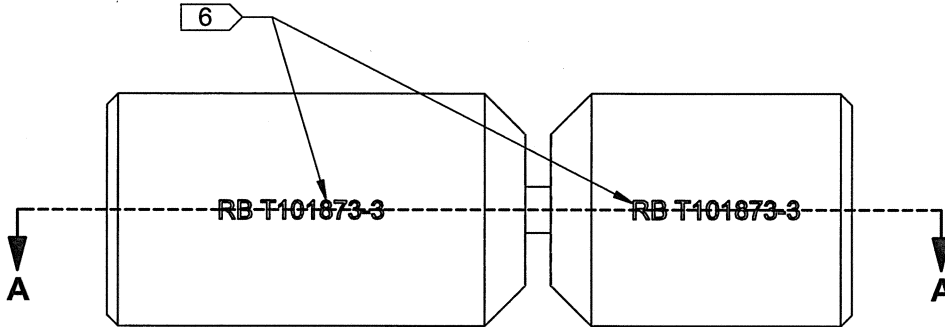
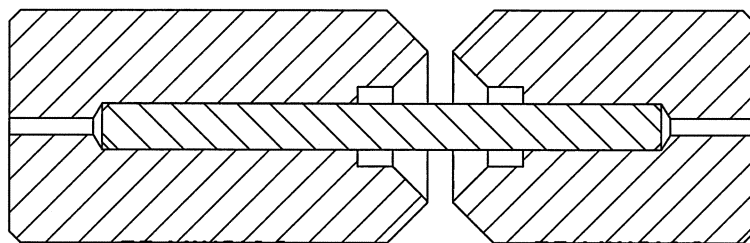
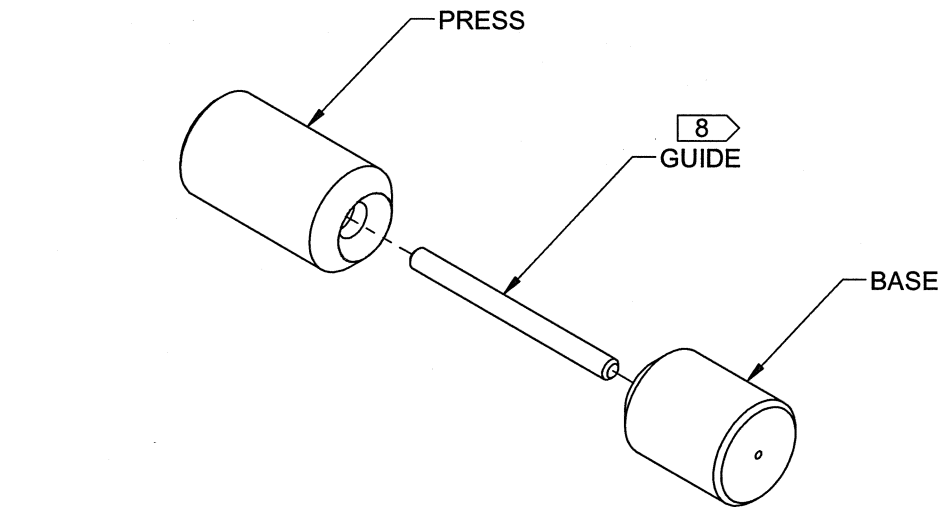


RB T101873-1 PACKAGING ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DATE 4/30/2019		RING STAKING TOOL	NTS
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	8	7	6	5	4	3	2	1			
	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ITEM #	PART #	PART TITLE
								X	-3	RB T101873-3	3 ASSY
								1	-39	RB T101873-39	PRESS
								1	-41	RB T101873-41	GUIDE
								1	-43	RB T101873-43	BASE
D								X	-5	RB T101873-5	5 ASSY
								1	-45	RB T101873-45	PRESS
								1	-47	RB T101873-47	GUIDE
								1	-49	RB T101873-49	BASE
						X			-7	RB T101873-7	7 ASSY
						1			-51	RB T101873-51	PRESS
						1			-53	RB T101873-53	GUIDE
						1			-55	RB T101873-55	BASE
					X				-9	RB T101873-9	9 ASSY
					1				-57	RB T101873-57	PRESS
					1				-59	RB T101873-59	GUIDE
					1				-61	RB T101873-61	BASE
C				X					-11	RB T101873-11	11 ASSY
				1					-63	RB T101873-63	PRESS
				1					-65	RB T101873-65	GUIDE
				1					-67	RB T101873-67	BASE
			X						-13	RB T101873-13	13 ASSY
			1						-69	RB T101873-69	PRESS
			1						-71	RB T101873-71	GUIDE
			1						-73	RB T101873-73	BASE
		X							-15	RB T101873-15	15 ASSY
		1							-75	RB T101873-75	PRESS
		1							-77	RB T101873-77	GUIDE
		1							-79	RB T101873-79	BASE
B	X								-17	RB T101873-17	17 ASSY
	1								-81	RB T101873-81	PRESS
	1								-83	RB T101873-83	GUIDE
	1								-85	RB T101873-85	BASE
X									-19	RB T101873-19	19 ASSY
1									-87	RB T101873-87	PRESS
1									-89	RB T101873-89	GUIDE
1									-91	RB T101873-91	BASE

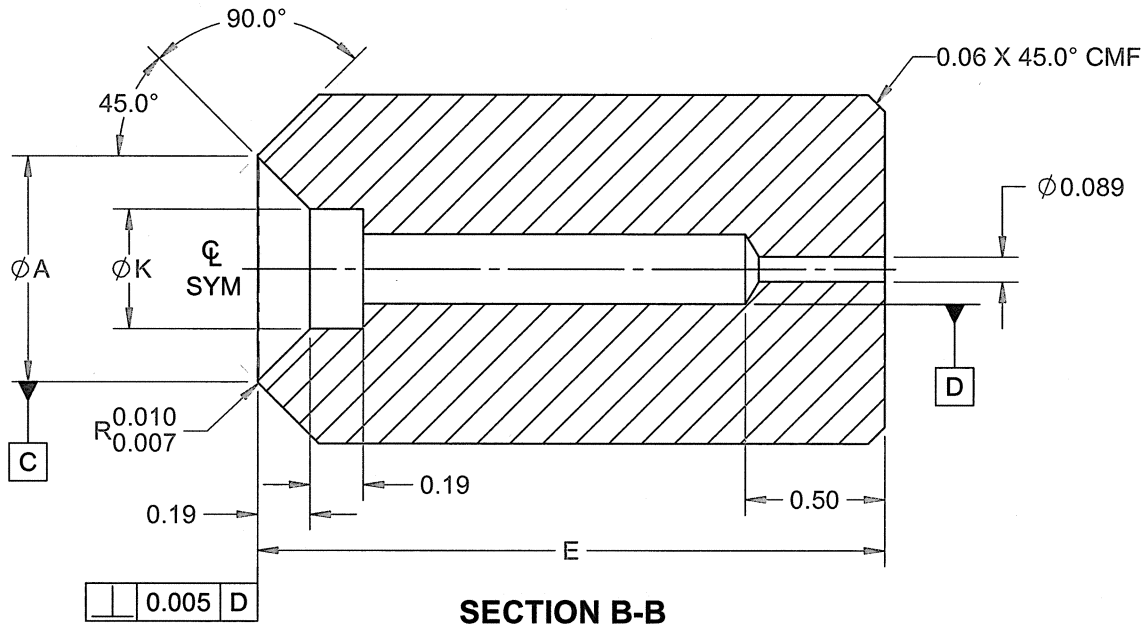
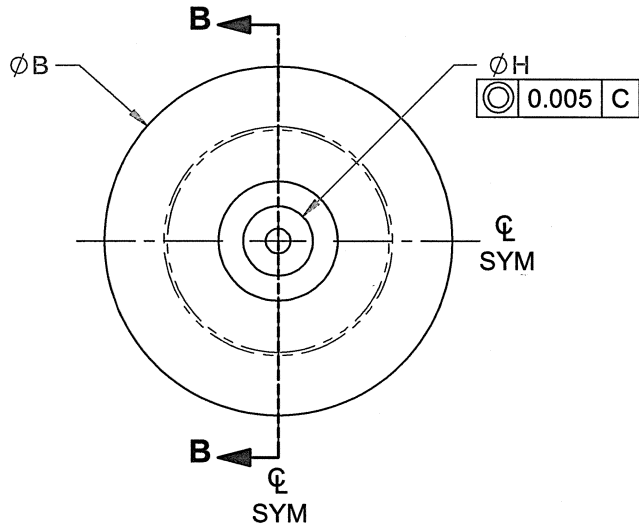
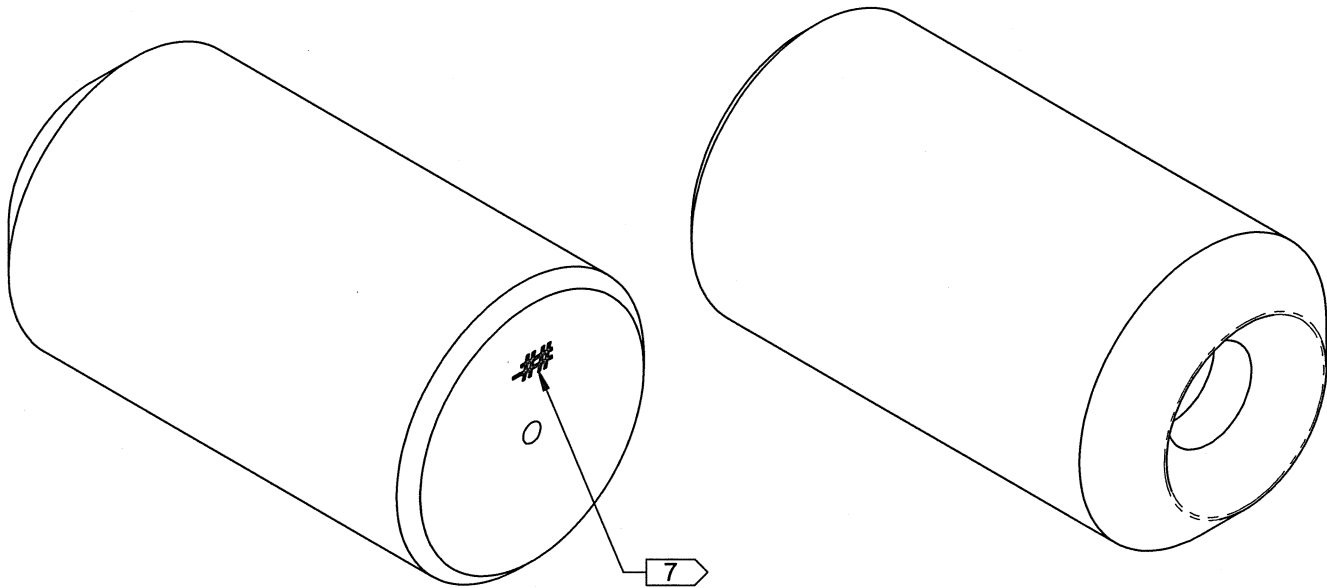


RB T101873-3, -5, -7, -9, -11, -13, -15, -17 & -19 ASSY
(RB T101873-3 SHOWN)

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: MACHINE ENGRAVE T/N AS SHOWN
7) ASSEMBLE AS SHOWN
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT GUIDE WITH BASE, AND REMOVE EXCESS

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 3 OF 9
APPROVED	<i>WJP</i>	TITLE	SCALE
		RING STAKING TOOL	NTS
DATE	4/30/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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TABLE 1 PRESS					
PART #	DIMENSION A ±0.0025	DIMENSION B	DIMENSION E ±0.03	DIMENSION H +0.0008/-0.0000	DIMENSION K
RB T101873-39	0.8085	1.250	2.25	0.2500	0.429
RB T101873-45	0.8422	1.250	2.00	0.1800	0.462
RB T101873-51	0.8752	1.250	2.00	0.3125	0.495
RB T101873-57	0.9377	1.500	2.25	0.3750	0.558
RB T101873-63	0.9377	1.500	2.25	0.3125	0.558
RB T101873-69	0.9692	1.500	2.00	0.2500	0.589
RB T101873-75	1.1257	1.500	2.25	0.3750	0.746
RB T101873-81	1.1877	1.500	2.75	0.5000	0.809
RB T101873-87	1.3127	1.750	2.25	0.3125	0.933

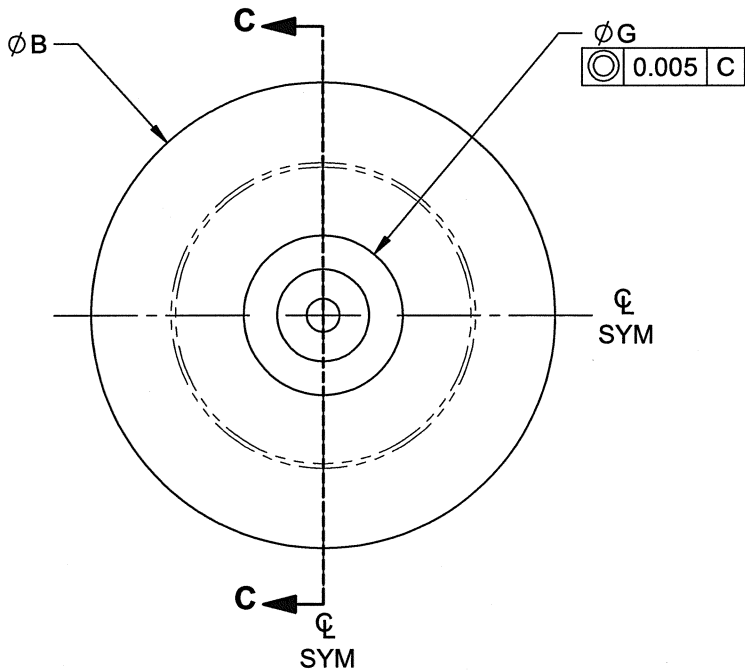
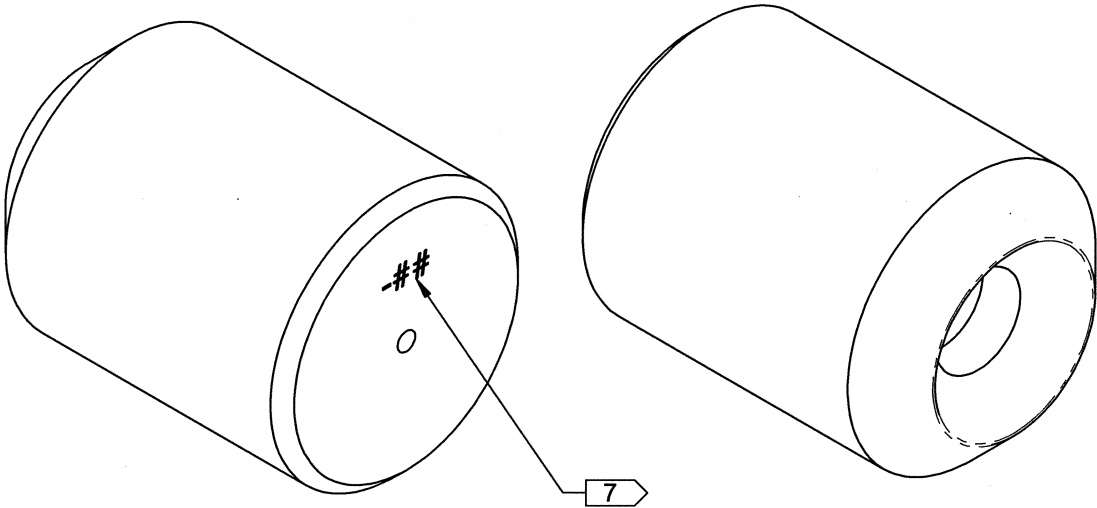


RB T101873-39, -45, -51, -57, -63, -69, -75, -81, -87 PRESS

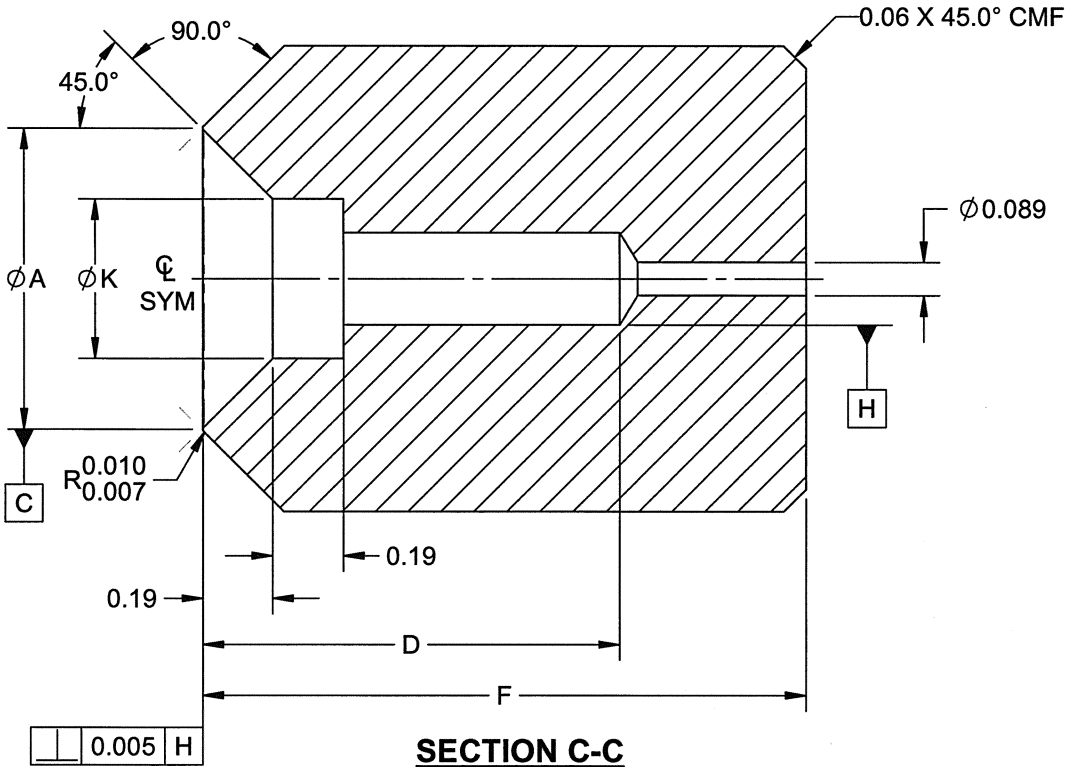
- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: RC 48-52
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE DASH # ONLY, AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 4 OF 9
APPROVED	<i>VP</i>	TITLE	SCALE
DATE	4/30/2019	RING STAKING TOOL	NTS
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TABLE 2 BASE						
PART #	DIMENSION A ±0.0025	DIMENSION B	DIMENSION D +0.01/-0.00	DIMENSION F ±0.03	DIMENSION G +0.0000/-0.0008	DIMENSION K
RB T101873-43	0.8085	1.250	1.12	1.62	0.2478	0.429
RB T101873-49	0.8422	1.250	1.00	1.50	0.1878	0.462
RB T101873-55	0.8752	1.250	1.38	1.88	0.3103	0.495
RB T101873-61	0.9377	1.500	1.50	2.00	0.3728	0.558
RB T101873-67	0.9377	1.500	1.50	2.00	0.3103	0.558
RB T101873-73	0.9692	1.500	1.25	1.75	0.2478	0.589
RB T101873-79	1.1257	1.500	1.50	2.00	0.3728	0.746
RB T101873-85	1.1877	1.500	2.00	2.50	0.4978	0.808
RB T101873-91	1.3127	1.750	1.25	1.75	0.3103	0.933



RB T101873-43, -49, -55, -61, -67, -73, -79, -85 & -91 BASE



- NOTES:
- 1) MATERIAL: O1
 - 2) HEAT TREAT: RC 48-52
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE DASH # ONLY, AS SHOWN

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A3
MFG. APPR.	J/K	RB T101873	SHEET 5 OF 9
APPROVED	W/P	TITLE	SCALE
		RING STAKING TOOL	NTS
DATE	02/05/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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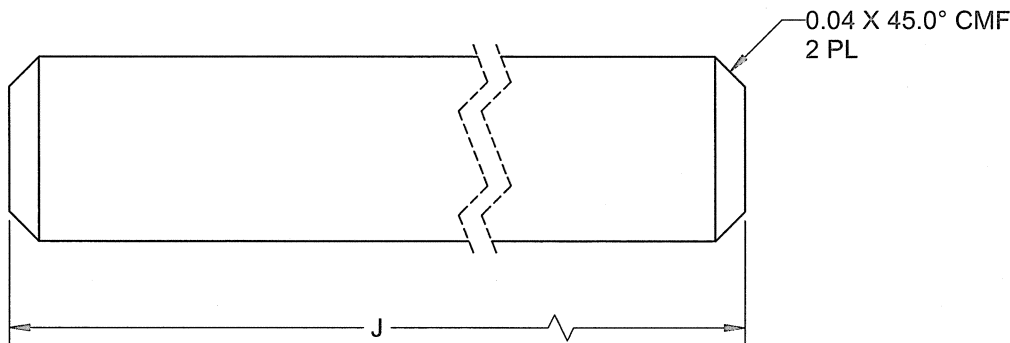
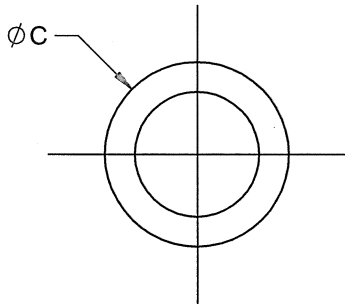
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TABLE 3
GUIDE

PART #	PURCHASE DOWEL PIN P/N (VERMONT PRECISION TOOLS)	DIMENSION C +0.0010/-0.0000	DIMENSION J
RB T101873-41	651214110	0.2480	3.00
RB T101873-47	651212110	0.1880	2.62
RB T101873-53	651218110	0.3105	3.00
RB T101873-59	651222110	0.3730	3.25
RB T101873-65	651218110	0.3105	3.88
RB T101873-71	651214110	0.2480	3.00
RB T101873-77	651222110	0.3730	4.00
RB T101873-83	651230110	0.4980	4.38
RB T101873-89	651218110	0.3105	3.12



RB T101873-41, -47, -53, -59, -65, -71, -77, -83 & -89 GUIDE

- NOTES:
- 1) MATERIAL: STD HARDENED DOWEL PIN (REFER TO TABLE 3)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 6 OF 9
APPROVED		TITLE	SCALE
		RING STAKING TOOL	NTS
DATE	4/30/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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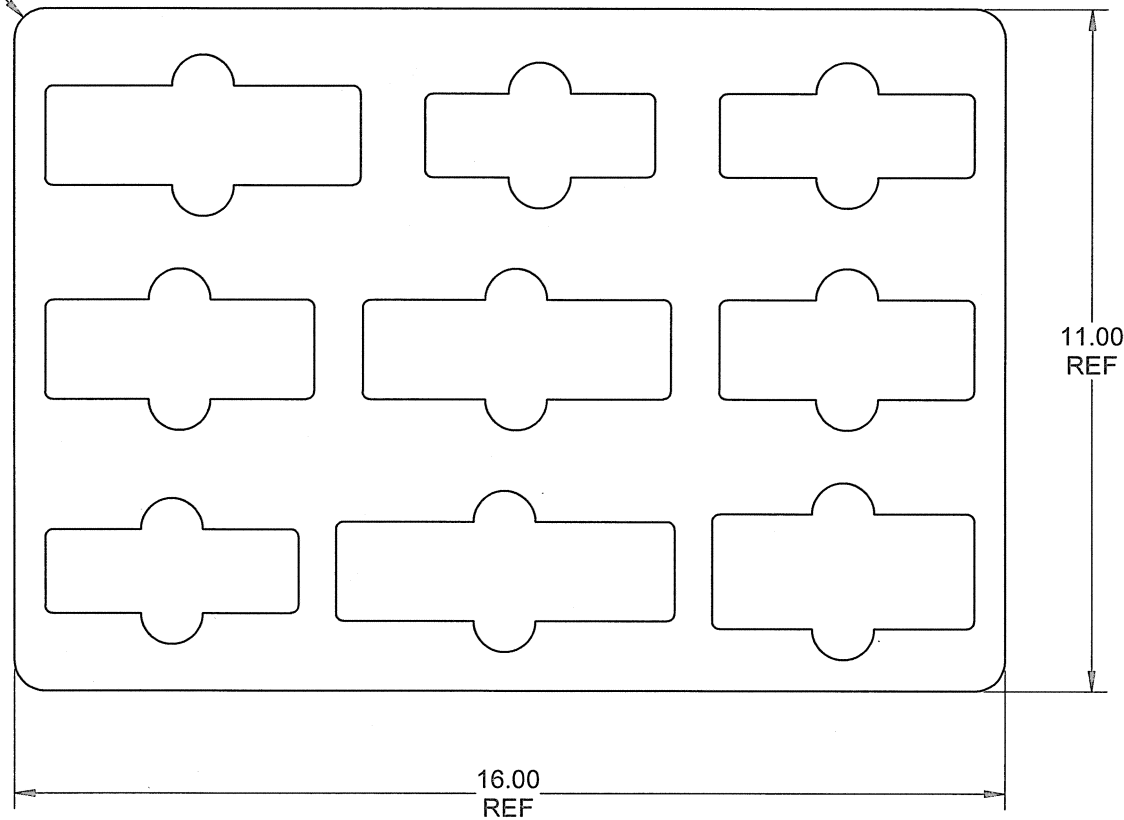
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R0.50
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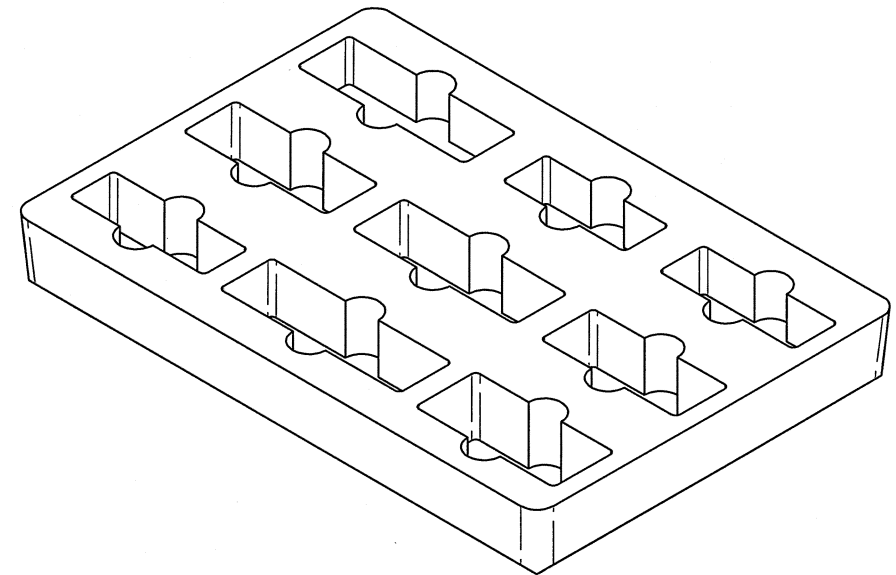


RB T101873-93 BOTTOM FOAM

7

94.0°
4 PL
REF

2.30
REF



D

C

B

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220 REF

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°



X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB T101873-93 REV. D.STEP

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DATE	4/30/2019	RING STAKING TOOL	NTS 
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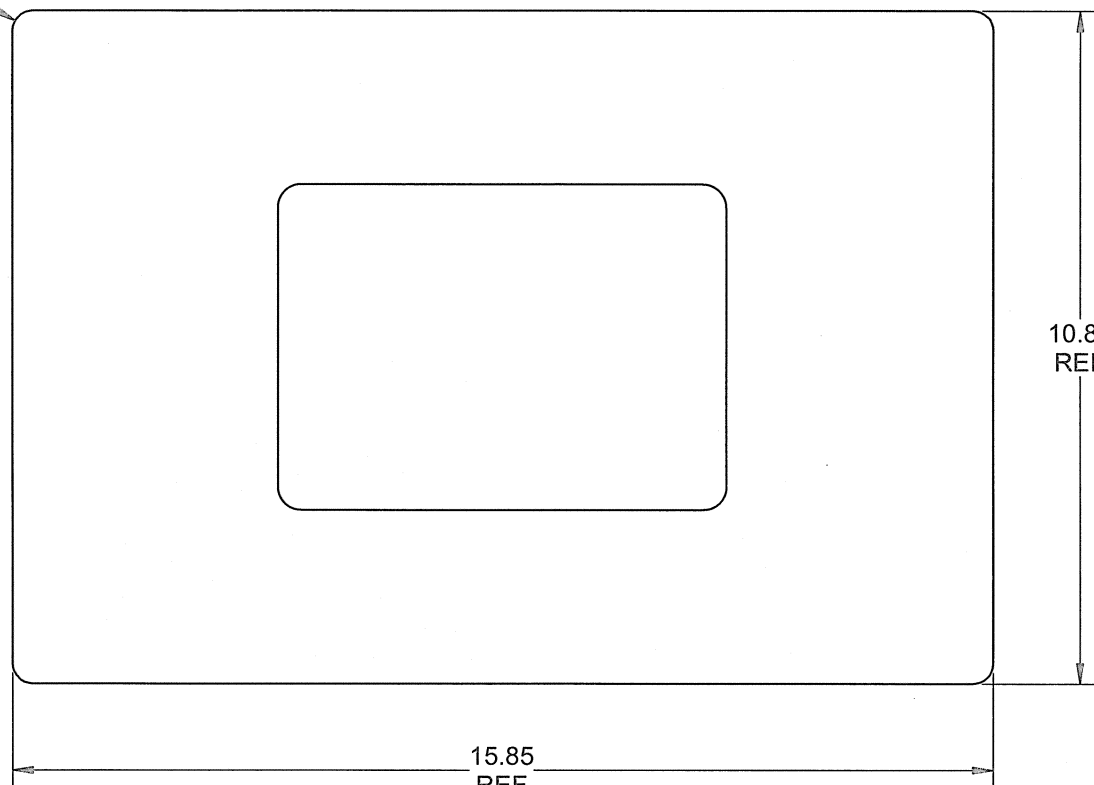
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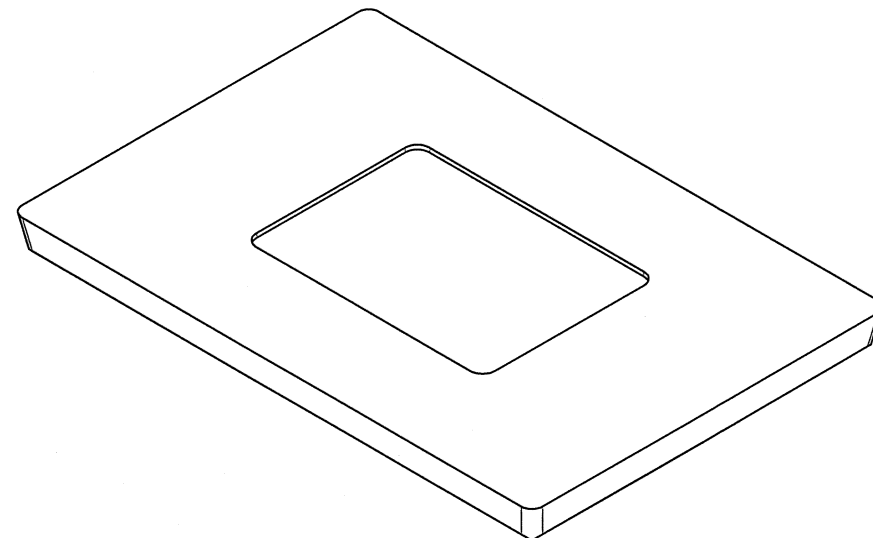
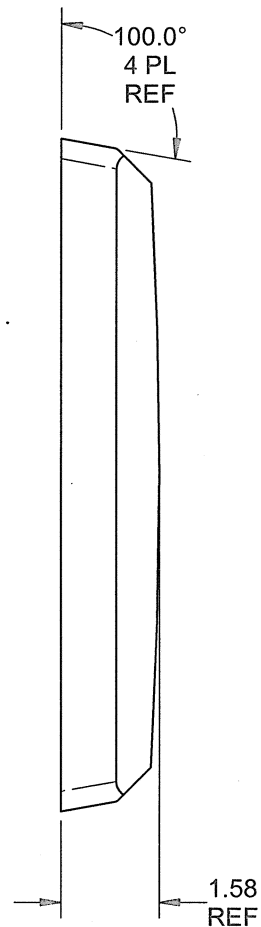
B

R0.33
4 PL
REF



RB T101873-95 TOP FOAM

7



D

C

B

NOTES:

1) MATERIAL: BLACK ETHAFOAM 220 REF

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB T101873-95 REV. D.STEP

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. D
DRAWN	MBB			
CHECKED	KPT	TOOL PART #	RB T101873	SHEET 8 OF 9
MFG. APPR.	JFC	TITLE		
APPROVED		RING STAKING TOOL	SCALE NTS	
DATE	4/30/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

D

C

B

A

R0.25
4 PL

7

97499- RB T101873 TOOL SET APPLICATION MFG-0E1A0						
TOOL NO.		SLEEVE	BEARING		SLEEVE	BEARING
RB T101873	-3	120-012-4	KP4A	-13	120-011-4	KP4
		120-015-4K	DW4K		120-013-4	KS4
	-5	120-011-3	KP3	-15	120-014-4	DSP4
		120-013-3	DSP3		120-015-6	DSRP4
	-7	120-014-3	DSP3	-17	120-012-8	DPP4
		120-012-5	DPP3		120-011-5	DW6
	-9	120-012-6	KP5A	-19	120-013-5	KP8A
		120-015-5	KP6A		120-011-5	KP5
	-11	120-012-6	DPS5	-19	120-013-5	KS5
		120-015-5	DSRP5		120-014-5	DPP5

RB T101873-97 CONTENT PLACARD

8

NOTES:

- 1) MATERIAL: JOHNSON PLASTICS #LM922402 OR EQUIV. (BLACK/WHITE MICROSURFACED IMPACT ACRYLIC 1/16" THK.)
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) BLACK BACKGROUND WITH WHITE LETTERS AND LINES
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB T101873-97 REV. D.DXF

DESIGN	MBB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MBB		
CHECKED	KPT	TOOL PART #	REV. D
MFG. APPR.	JFC	RB T101873	SHEET 9 OF 9
APPROVED	WY	TITLE	SCALE
DATE	4/30/2019	RING STAKING TOOL	NTS
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